

Work Order ID 57278

March 31, 2010 12:43:31 PM



Page 1

Item ID: D2267

Accept



Setup Start



Revision ID:

Item Name: L Bracket

Stop



Start Date: 31/03/2010 Start Qty: 10.00



Required Date: 09/04/2010 Req'd Qty: 10.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: *M*

Date: *10-3-31*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2267

Rev C

100



SHEAR

0.00

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2267

Dwg Rev: *E*

Prog Rev: *E*

2-Deburr if necessary

=7 m-h

10/04/12

(13X)

(13)

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

13 10-4-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 57278

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Item Name: L Bracket

Start Date: 31/03/2010 Start Qty: 10.00

Required Date: 09/04/2010 Req'd Qty: 10.00

Reference:

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Quality Control

Memo

0.00

S 06/04/12

(13)

130 .0



Brake NC

Brake NC

Bend as per dwg
Small Fab

0.00

Memo

0.00

SB 06/04/13

(13)

P13 →

130.1 QCS inspect work to current step
S 06/04/13

0.00

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1





0.00

Memo

BR 10-4-13

(13)

Dart Aerospace Ltd

W/O: 57278		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/04/13	130.1	perm. change Add ACS inspect work to current step		10.04.14			
		ACS inspect work →	S	10/04/13	+13		10/04/13
10/04/13	150	change ACS to QC3		10.04.14			

Part No: D2267 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 57278

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Item ID: D2267

Revision ID:

Item Name: L Bracket

Start Date: 31/03/2010 Start Qty: 10.00

Required Date: 09/04/2010 Req'd Qty: 10.00

Reference:

Accept

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC

Quality Control

~~QC5- inspect part completeness to step on W/O~~

0.00

883 inspect chemical conversion
10/04/13 Memo

0.00

JD 10/04/13

13

9

160

Packaging

Packaging

Identify as per dwg & Stock Location: *010*

0.00

Memo

0.00

10/04/13 (13)

170

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/04/14

MF

10-4-14

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

March 31, 2010 12:43:35 PM

Page 1

Work Order ID: 57278

Parent Item: D2267

Parent Item Name: L Bracket

Comments: IPP B 02.02.05 Re format NG
now on waterjet DD 10.03.31 verified by:EC

IPP Rev:C

Start Date: 31/03/2010

Required Date: 09/04/2010

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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M2024T3S.040

Purchased

No

100

sf

486.7893

0.4084

.6

2024-T3 .040 sheet

Warehouse

Location

Main Warehouse

MAT22

Loc Qty

Loc Code

110305

486.7892789

162.816

110337

6.4

111786

32.0665789

112291

47.6864

112331

82.8641

113162

154.9562

110305

(13)

10-4-7

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

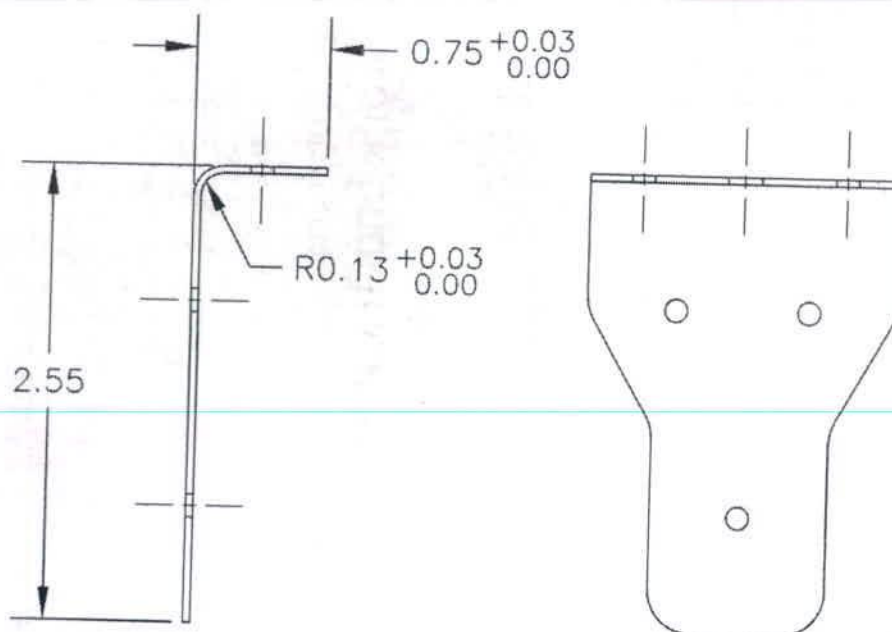
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**DART**

DESIGN MC	DRAWN BY H	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D2267	REV. C
DATE 01.06.14		TITLE L-BRACKET	SHEET 1 OF 2 SCALE 1:1
A	94.09.15	NEW ISSUE	
B	96.06.04	REDRAWN	
C	01.06.14	R0.13 WAS R0.94; ADDED FLAT PATTERN	



D2267 BEND DETAIL

RELEASED
d.d.25 H

MATERIAL: 2024-T3 (QQ-A-250/4) 0.040" THICK
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
BREAK ALL SHARP EDGES 0.005 TO 0.010
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37278

H10-3-31

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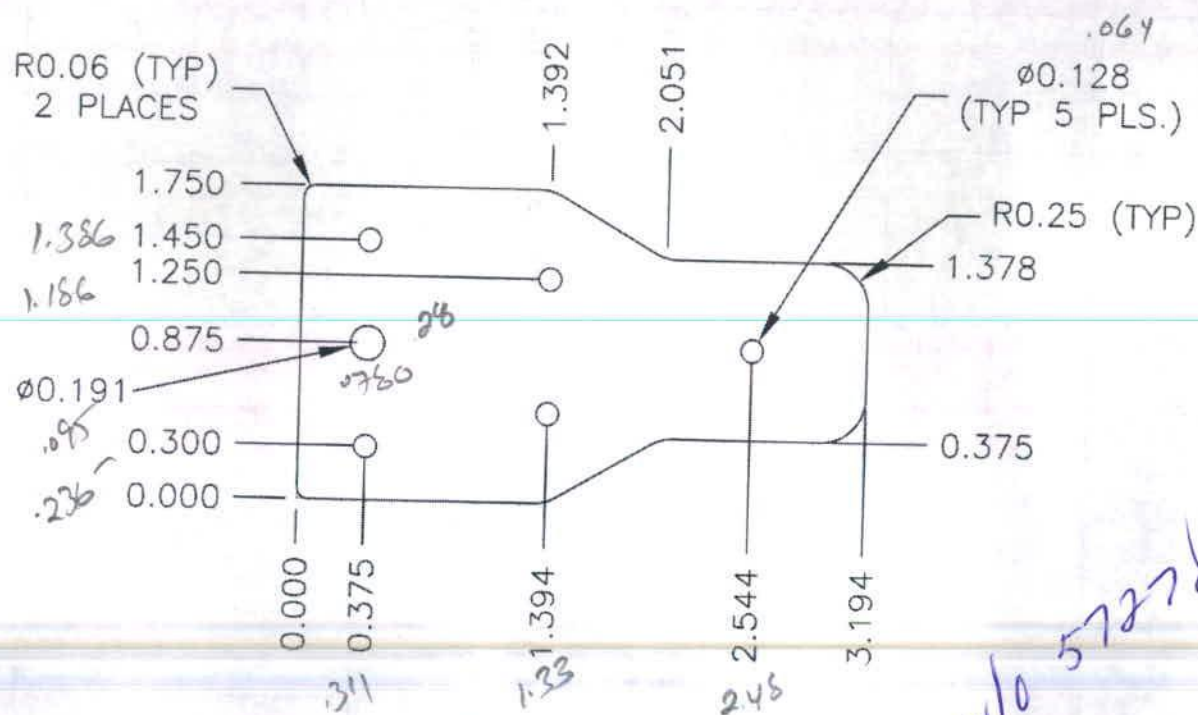
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DESIGN MC	DRAWN BY 77	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2267	REV. C SHEET 2 OF 2
DATE 01.06.14		TITLE L-BRACKET	SCALE 1:1



D2267 FLAT PATTERN

RELEASED
01.06.25

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